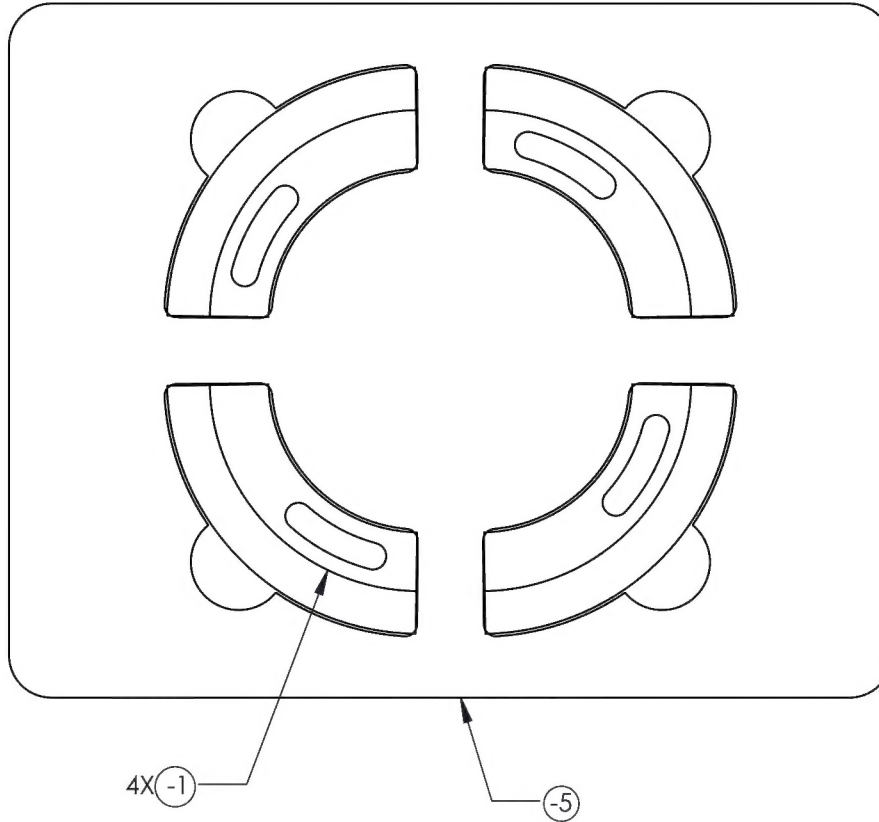



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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D TOOL NAME WAS DROOP RING CENTERING IS TOOL ASSY. FLOATING RING CENTERING.	11/8/2013	RJC	RW

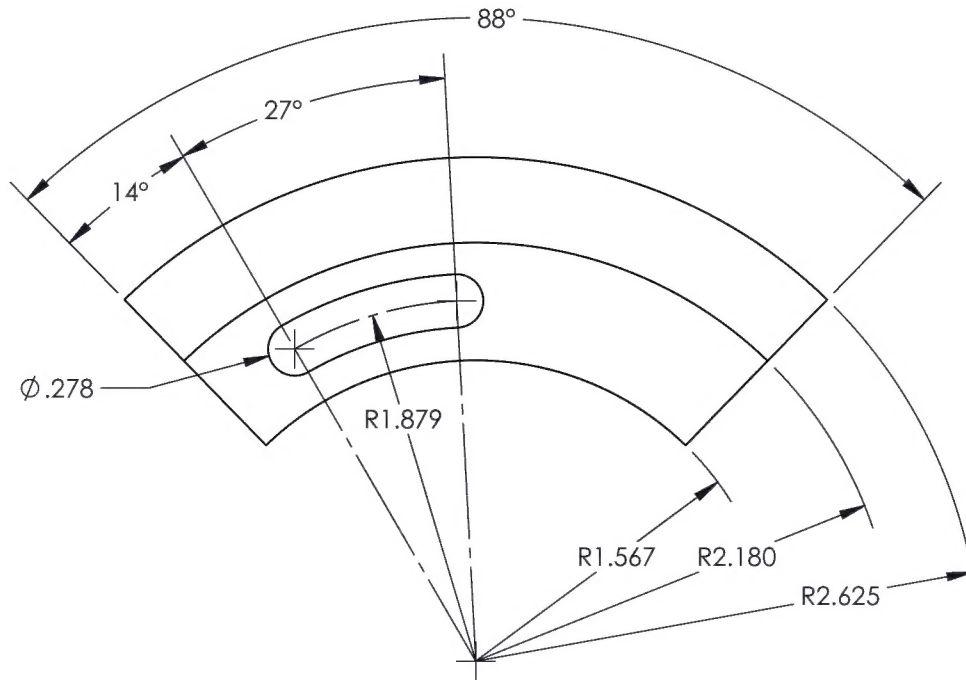


ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	4	RING	6061	1-3/4 x 1-3/4 x 3-7/8	2
		B/O	-3	1	CASE	PLASTIC	PELICAN #APP-1200-E	N/S
		B/O	-5	1	BOTTOM FOAM	Y-20, BLACK	2-15/16 X 7-1/4 X 9-3/16 I.R. SPECIALTIES	3
		B/O	-7	1	LID FOAM	Y-20, BLACK	1-3/16 X 7-1/8 X 9-3/8 I.R. SPECIALTIES	4
		B/O	-9	1	RED BARN PLACARD	PLASTIC	RB41009	N/S

 <b>RED BARN MACHINE</b>	
<b>TITLE</b> TOOL ASSY. FLOATING RING CENTERING	
<b>DWG NO.</b> RBW109-3101-86-101	<b>REV</b> A
<b>MAT'L</b> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	<b>DRAWN BY:</b> CLOUGH <b>APPROVED</b> <i>D Weil</i> <b>HEAT TREAT</b> <b>FINISH</b> <b>SPEC</b> 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
<b>SCALE</b> 1:2 <b>DATE</b> 12/18/2012	<b>USED ON MODEL</b> A109E, A119 <b>SHEET 1 OF 4</b>

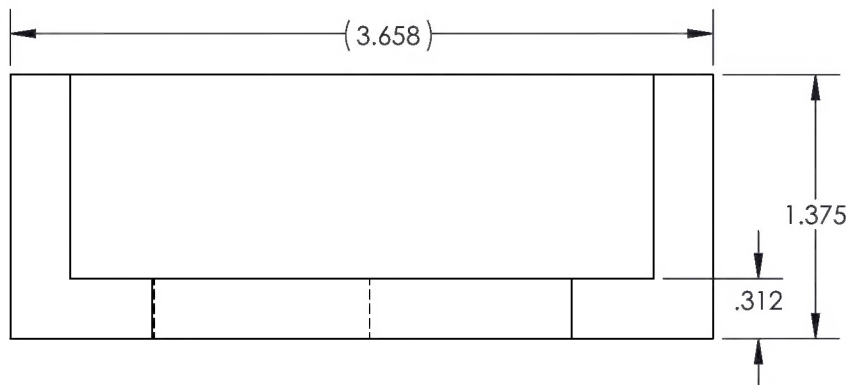
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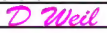
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
			APPROVED



①

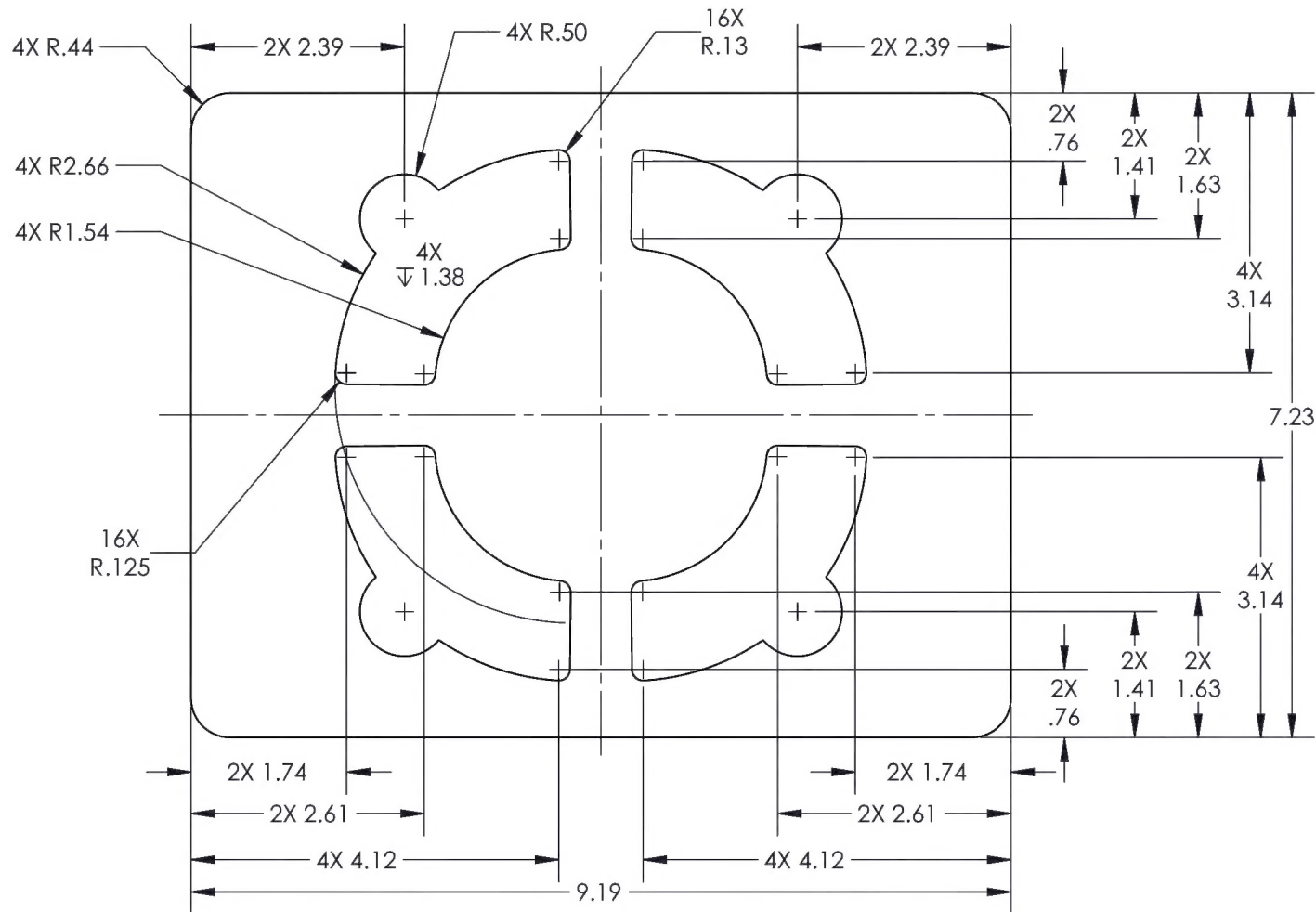
RING



 <b>RED BARN MACHINE</b>	
<b>TITLE</b> TOOL ASSY. FLOATING RING CENTERING	
<b>DWG NO.</b> RBW109-3101-86-101-1	<b>REV</b> A
<b>MAT'L</b> 6061	<b>DRAWN BY:</b> CLOUGH
<b>UNLESS OTHERWISE SPECIFIED</b> <b>DIMENSIONS ARE IN INCHES</b> .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	<b>APPROVED</b>  <b>HEAT TREAT</b> CLEAR ANODIZE <b>SPEC</b> MIL-A-8625F, TYPE II, CLASS I <b>USED ON MODEL</b> A109E, A119
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
<b>SCALE</b> 1:1	<b>DATE</b> 12/18/2012
SHEET 2 OF 4	

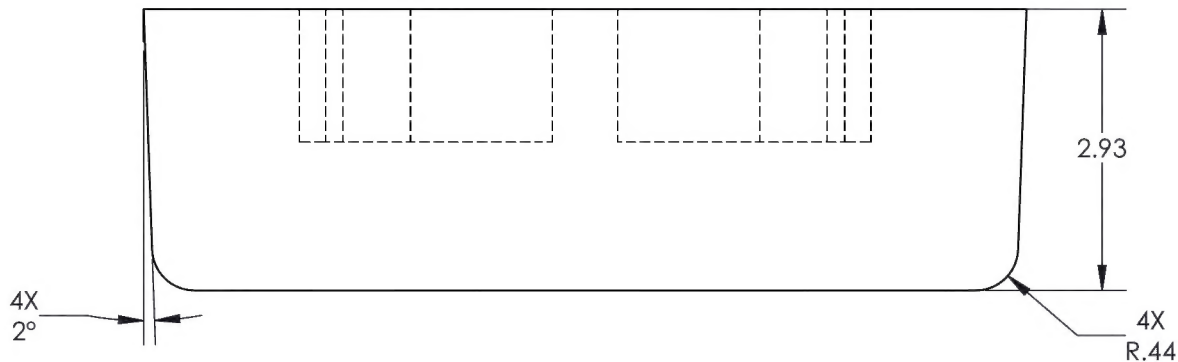
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



⑤

BOTTOM FOAM

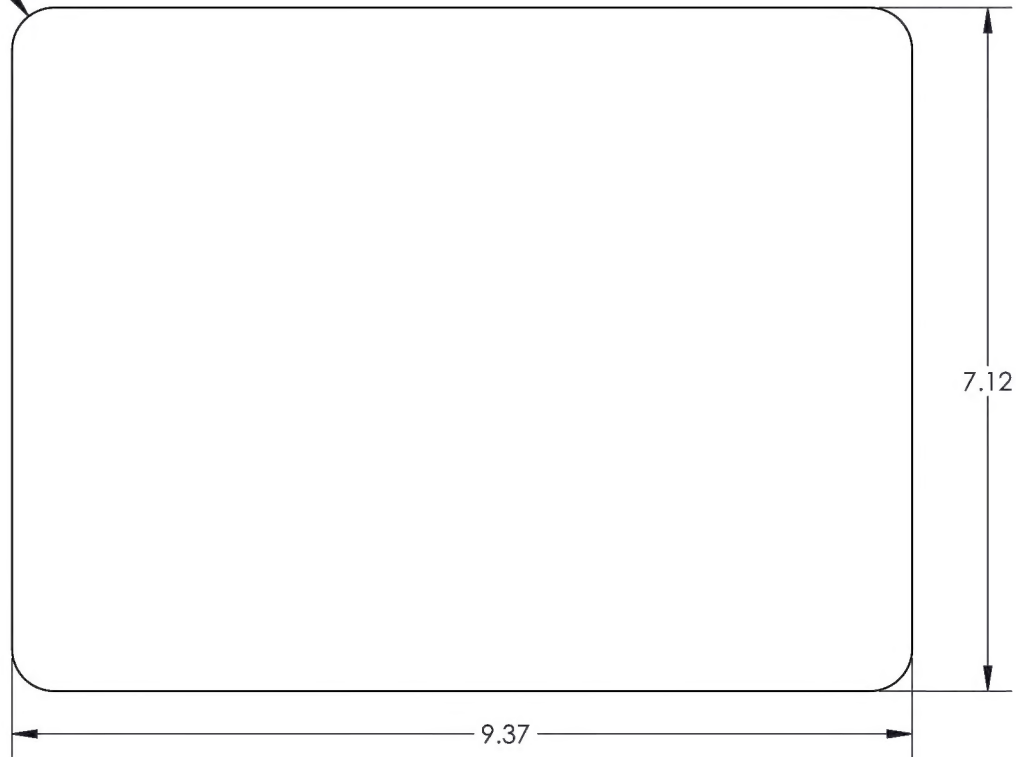


 <b>RED BARN MACHINE</b>	
<b>TITLE</b> TOOL ASSY. FLOATING RING CENTERING	
<b>DWG NO.</b> RBW109-3101-86-101-5	<b>REV</b> A
<b>MAT'L</b> Y-20, BLACK	<b>DRAWN BY:</b> CLOUGH
<b>UNLESS OTHERWISE SPECIFIED</b> DIMENSIONS ARE IN INCHES .XXX $\pm$ .005 .XX $\pm$ .01 .X $\pm$ .1 FRACTIONS $\pm$ 1/32 ANGLES $\pm$ 5°	<b>APPROVED</b> 
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	<b>HEAT TREAT</b> <b>FINISH</b> <b>SPEC</b> USED ON MODEL A109E, A119
<b>SCALE</b> 1:2	<b>DATE</b> 12/18/2012
SHEET 3 OF 4	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

4X R.44

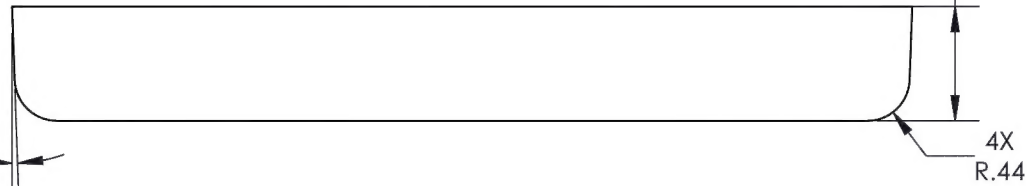



(-7)

LID FOAM

1.19

4X 2°



 <b>RED BARN MACHINE</b>	
TITLE <b>TOOL ASSY. FLOATING RING CENTERING</b>	
DWG NO. <b>RBW109-3101-86-101-7</b>	REV <b>A</b>
MAT'L Y-20, BLACK	DRAWN BY: <b>CLOUGH</b>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	<b>A109E, A119</b>
SCALE 1:2	DATE 12/18/2012
SHEET 4 OF 4	